LET	ALTERATION	DATE	BY
M	TRACED	[illegible]	[illegible]
N	CHANGED -4-5-6-7-28-29-30 & -31 FROM ST. TO SO.	1-26-38	[illegible]
O	[illegible] ASSY FOR PBY-5	11-17-39	[illegible]
	REPLACED -32 & -33 WITH -39 & -40 RESPECTIVELY FOR PBY-5.	[illegible]	[illegible]
P	ADDED 288073 & 288075 CLIPS		
Q	REMOVED -21 & 22 FROM -550 ASSY		
R	ADDED -41L TO DRAWING FOR -550 ASSY ONLY		

15780
17420
15150

UPPER HALF OF BELTFRAME STA. 6.4 SEE 28B1640 (PBY-1 & FUTURE) (REF.)

SECT. A-A

SECT. B-B

STRINGER

DO NOT USE ON -550 ASSY
(-21) L.H.
(-22) R.H. USE INSTEAD 288075 AS SHOWN IN SECT. D-D

SECT. C-C

AN442-D5

SECT. E-E

END OF 28B640-32 & 33

L.H. (-32) BULB ANGLE 7/8 x 9/16 x .060 ALCOA DIE K1589 - AL ALLOY (24ST) SPEC. 46A9 - COND. T
R.H. (-33) PBY-1, 2, 3, 4

CUT -39 HERE

TRIM -39 ON INSTALL. OF 28B4126

VIEW F-F

NOTE: ON PBY-1 & PBY-2 INSTALL -28 ON FORWARD SIDE AS INDICATED BY DOTTED LINES.
ON PBY-3 & FUTURE PBY-1'S & PBY-2'S PART -25 IS CANCELLED & REQ'M'TS. FOR -24 INCREASED FROM 1 TO 2 REQ'D. -24 IS THEN INSTALLED ON LEFT & RIGHT HAND SIDES

PBY-3 & FUTURE

-550 ASSY ONLY

SECT. D-D

AN442-D6

ALCOA DIE K-1559 SPEC. 46A9 - COND. T (39) L.H. (40) R.H. ON -550 ASSY

(-25) L.H. (-26) R.H. .030 SHEET AL ALLOY (24SO) SPEC. 47A10 - COND. A - H.T. SR53 (COND. T)

8-3/32 RIVETS EQUALLY SPACED

VIEW H
TYPICAL ATTACHMENT OF STIFFENERS TO CORD MEMBERS UPPER & LOWER. THIS VIEW APPLIES TO PBY-2 & FUTURE

288212 CLIP ON PORT SIDE ONLY

AC425-D4

SECT. G-G

FORWARD

ALL WEB STIFFENERS TO BE JOGGLED 1/16 WHERE NECESSARY. OUTSTANDING LEG TO BE TRIMMED 30°

USE ON -550 ASSY ONLY
(-41) L.H. 3/4 x 3/4 x 1/16 x 5 - K5401
RIVETS IN TOP & BOTTOM EDGEING ANGLES TO BE EQUALLY SPACED AS SHOWN IN EACH SPACE BETWEEN WEB STIFFENERS

SEE VIEW H

L.H.	R.H.		
-4	-5	FRONT TOP ANGLE	5/8 x 1/2 x .060 ANGLE DIE K5876 PBY-1 ONLY
-6	-7	REAR TOP ANGLE	
-28	-29	FRONT BOTTOM ANGLE	5/8 x 5/8 x 1/16 PLAIN ANGLE DIE M-1282 PBY-2 & FUTURE
-30	-31	REAR BOTTOM ANGLE	SPEC. 46A9 - COND. A 24SO AL ALLOY HEAT TREAT SR 53 COND. T

(-2) WEB .025 SHEET AL ALLOY (24ST) SPEC. 47A10 - COND. T FOR -0 ASSY
(-38) WEB .020 SHEET AL ALLOY (24ST) SPEC. 47A10 - COND. T FOR -550 ASSY
RIVETS IN WEB STIFFENERS TO BE EQUALLY SPACED AS SHOWN

(-34) AL ALLOY (24ST) SPEC. 47A10 GUSSET .051 SHEET REAR FACE ONLY

28B1828 ON PBY-1 & FUTURE

BEND ANGLES SEE SECT. L-L 28B1828

DRILL 28B1391 Q5761-KS-1.5 AN510-D6-8 AN345-D6

BEVEL CONSTANT BETWEEN THESE POINTS

288073 CLIP -550 ASSY

CLIP 288070

AN442-D6

5 3/8 ON PBY-1 & FUTURE

WEB STIFFENERS PART NOS. -8-9-10-11-12-13-14-15-16-17-18-19 & -20 TO BE 9/16 x 9/16 x .040 EXTR ANGLES ALCOA DIE K-6240 - AL ALLOY (24ST) SPEC. 46A9 COND. T

DIAGONAL BRACES PART NOS. -21-22-23 & -24 TO BE 5/8 x 1/2 x 1/16 EXTR. ANGLES ALCOA DIE K-5876 AL ALLOY (24ST) SPEC. 46A9 COND. T

288075 CLIP -550 ASSY

KEEL LINE

SEE SECT. B-B

(-35) AL. ALLOY (24ST) SPEC. 47A10 COND. T GUSSET .051 SHEET REAR FACE ONLY

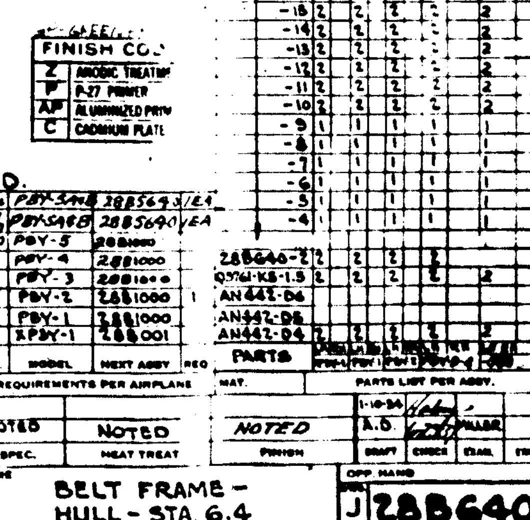
BELT FRAME STA. 6.4
PORT SIDE - LOOKING FORW'D.

FINISH CODE	
Z	ANODIC TREATMENT
P	P-27 PRIMER
AP	ALUMINIZED PRIMER
C	CADMIUM PLATE

FINISH:
Z-P-2 ON PBY-1 & XP3Y-1
Z-P-2 ON PBY-2 & FUTURE

UNLESS OTHERWISE SPECIFIED ALL RIVETS ARE AN442-D5
5/32 DRILL FOR AN442-D5
3/16 " " AN442-D6

ALL AL. ALLOY SHEET 24 ST. SPEC. 47A10 EXCEPT AS NOTED
ALL AL. ALLOY EXTRUSIONS 24ST EXCEPT AS NOTED
HT. ALL COND. A MATERIAL SPEC SR-53 TO COND. T
RIVETS AL ALLOY EXCEPT AS NOTED



PARTS	MAT.
28B640-2	
Q5761-KS-1.5	
AN442-D6	
AN442-D5	
AN442-D4	

PARTS LIST PER ASSY.

	MODEL	NEXT ASSY	REQ
-21 -26	PBY-5A & B	28B5693	1/EA
-39 -40	PBY-5A & B	28B5690	1/EA
-550	PBY-5	28B1000	
	PBY-4	28B1000	
	PBY-3	28B1000	
	PBY-2	28B1000	1
	PBY-1	28B1000	
	XP3Y-1	28B001	

REQUIREMENTS PER AIRPLANE

REPLACES
REPLACED BY
LIMIT ON DIMENSIONS UNLESS OTHERWISE SPECIFIED ± 1/32

[redacted]

APPROVED 8-24-37 DATE
7.20 CALC. WT. ACT WT.
SCALE 6"=1'-0" 12"=1'-0"
AC
NAVY NOTED
MATERIAL NOTED SPEC. NOTED HEAT TREAT NOTED FINISH
1-10-34 A.D. DRAFT CHECK EXAM. ENG.

CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.

NAME BELT FRAME - HULL - STA 6.4

J 28B640

H 64